

Date: Thursday, 5/25/2006 3:26:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RAPPEL ANCHOR
Job Number : 27245	
Estimate Number : 11069	
P.O. Number : NIA	Part Number : D2224
This Issue : 5/25/2006 S.O. No. : NIA	Drawing Number : D2224 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 26029	Material : NIA
Written By : <i>Shirley</i> COMMENT BY <i>Shirley</i>	Due Date : 6/15/2006
Checked & Approved By : <i>06.05.25</i>	Qty: <i>7</i> Um: Each
Comment : Est Rev: 02.04.23 Add note for grain direction & inspect 8, 21 N G	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M7075T73B2500X0325	7075-T73 Bar 2.5 x 3.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.2321 f(s)/Unit Total : 1.3923 f(s)
 7075-T73 Bar 2.5 x 3.25"
 (M7075T7B0325X0320)
 Batch: *M17646*

J.G 06/06/01 7

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 2.660" +.030" / -.010"
 *****Note grain direction *****

J.G 06/06/01 7

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio D2224 & Dwg D2224

2-Deburr & Tumble

J.F. 06/06/04 6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/04 6


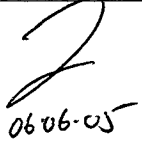

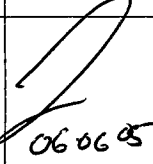
5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.G 06/06/04 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/08	3	The 507" hole is off of 1200" 1st part - took orig. in at wrong location.		Scrap; destroy. No Replace.	J.F. 06/06/05	 0606-05		 060605

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/25/2006 3:26:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RAPPEL ANCHOR

Job Number: 27245

Part Number: D2224

Job Number:



Seq. #:

Machine Or Operation:

Description :

06/06/15 (6)

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: *1411*

Red Anodize as per Dwg D2224 MIL-A-8625

C 20060606 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

AL 06/06/12 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

AL 06/06/12 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST369*

AL 06/06/12 (6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/06/14 (6)

Job Completion



u 06-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

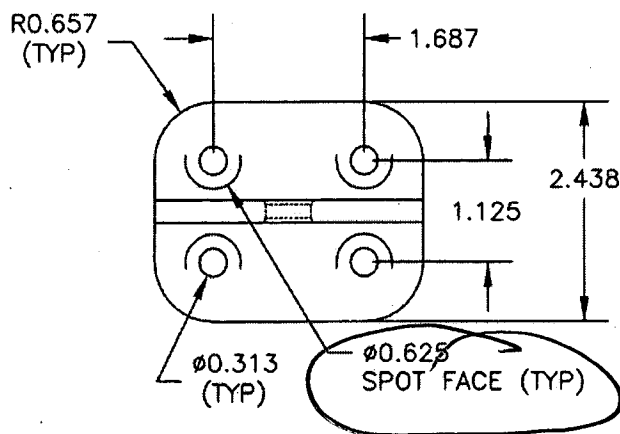
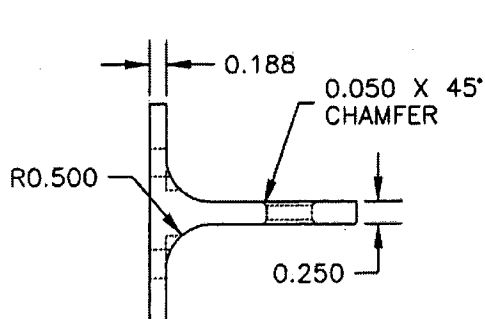
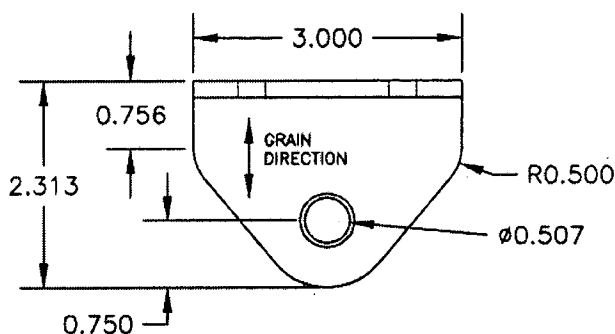
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



RELEASED
99.09.11 KE

DESIGN DA	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED DA	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 27245

DART AEROSPACE LTD		Work Order:	27245
Description: RARREL ANCHOR		Part Number:	02224
Inspection Dwg: 02224 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000"	±.010"	3.008"				
.756"	±.010"	.756"				
2.313"	±.010"	2.311"				
.750"	±.010"	.749"				
Ø.507"	±.008"	Ø.507"				
R0.500"	±.010"	R0.500"				
.188"	±.010"	.187"				
0.050x45°	±.010"	0.050x45°				
.250	±.010"	.250"				
R0.500"	±.010"	R0.500"				
R0.657"	±.010"	R0.657"				
1.687"	±.010"	1.690"				
Ø.313"	±.008"	Ø.318"				
1.125"	±.010"	1.125"				
2.438	±.010"	2.442"				
Ø.625	±.010"	.570"				

Measured by: J.F.	Audited by: J.G.	Prototype Approval:
Date: 06/06/03	Date: 06/06/04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

48162

09-Jun-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE:****PO00001411**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	D2224 B27246 -	MATL: AL RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

